

V6-LABEL/A3 V-Auto A3 Automatic Continuously Sheet Feed (ASF) Label Cutting Machine

USER MANUAL

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Use safety matters

Thank you for purchasing our die-cutting machine series products. Please read the safety warning and the following instructions carefully before use.

Warning symbol specification:

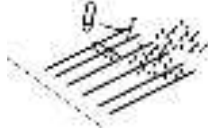
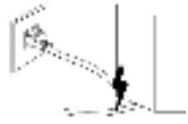
	WARNING	Improper operation may result in injury or equipment damage.
---	---------	--

	CAUTION	Improper operation may result in injury to persons or damage to other objects.
---	---------	--

Symbol specification:

	The symbol indicates that the user needs to pay high attention and attention, the pattern inside the triangle indicates the situation that should be paid attention to, and the picture on the left means "beware of electric shock".
	The symbol indicates the action that must be prohibited, and the pattern inside the circle indicates the prohibited action. The picture on the left means "do not disassemble".

	WARNING
	Do not use a power supply that does not meet the rated voltage. Use of non-compliant power supplies can result in fire or electric shock.
	Do not use the machine if it emits smoke, odor, noise and other abnormal conditions. In this case, continued use may cause fire or electric shock.
	It is strictly forbidden to pull the plug when the power is on Plugging in and unplugging the power while live will damage the machine.
	Ensure machine grounding If not grounded, electric shock or mechanical failure may occur.
	Do not disassemble, repair or modify the machine. Doing so can result in fire or electric shock, resulting in injury or death.
	CAUTION

	The machine shall not penetrate liquid, fall into metal objects, etc. These objects can cause fires.	
	Do not touch the tip of the knife with your fingers. This can lead to broken fingers.	
	Do not destroy or replace the original power cord at will. Do not bend, pull, bind or press the power cord under heavy objects. This can damage the power supply, causing an electric shock or fire.	
	If you do not use the engraving machine for a long time, please unplug the power cord from the socket. Otherwise it could cause a fire.	
	When operating, both hands should not be placed on the main shaft. This can lead to injury.	
	The machine should be placed on a firm surface. This could cause the machine to fall and cause injury.	
	When unplugging the power cord from the socket, the plug should be unplugged, and the cable should not be pulled. Pulling the cable too hard can cause an electric shock or fire.	
	Do not use it during thunderstorms and lightning. Lest lightning strike the machine.	

Installation Instructions

1. Random standard attachment

Open the package and check the following attachments. If anything is missing, please contact the seller or our company immediately.

Sequence number	item	quantity	figure
1	Power cable	1	
2	U disk	1	
3	USB Connecting line	1	
4	Net cable	1	
5	Rotary tool holder	1	
6	High speed tungsten steel knife	3	
7	Paper holder	1	
8	screw	1 pack	
9	Write the plug-in password	1	
10	certificate	1	
11	warranty card	1	

1.1.Schematic Diagram



The paper placement diagram is shown above.

2. Install Machinery

2.1 Installation And Connection



WARNING



Make sure the machine is grounded

If not grounded, it may cause electric shock or mechanical

failure.



Do not use a power supply that does not meet the rated voltage

Using a power source that does not comply with regulations can result in fire or electric shock.



Do not pull out the power plug when live

Live plugging will damage the machine.



The machine should be placed on a firm surface

Otherwise, the machine will fall and cause injury.



2.1.1 Place the cutter in a balanced, spacious area.

2.1.2 Connect the die-cutter to the computer with a USB cable.



2.1.3 Place the paper holder behind the host, so that the support and the host are fixed firmly.



2.1.4 Check the power supply voltage and ensure that the ground is grounded. Connect the power supply only after the check is correct.



Chapter One

LCD keyboard introduction: Chinese and English interface as shown below:



Machine control method:

1.Key operation

Panel description:

function button: , Pressure speed button: , Test button: ,

Repeat button: , QR code button: , U disk: ,

Direction move button: 

X move left button: , X move right button: ,

Y move back button: , Y move forward button: 

X,Y Reset button: ,

Chapter Two Operation detail

Boot LCD interface display



The X-axis returns to the mechanical origin every time you turn it on.

Section 1 : Pressure, speed setting Every time you turn on the X axis will return to the mechanical origin.

Press menu button  to interface



Press  key reduces pressure/speed, press  key increase pressure/speed, After adjusting the pressure and speed, press  save the adjusted parameters.

Section 2 :Installing a Tool



CAUTION



**Do not touch the tip of the knife
with your fingers**

This can hurt the fingers and
blunt the blade.



2.1 Put the cutting knife into the rotating tool, the knife and tool are shown below:

(Outside view)

(Breakdown diagram)

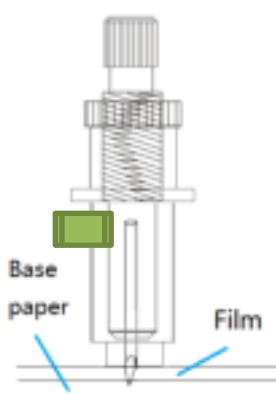


Tool adjustment nut

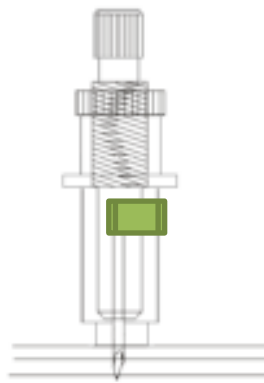
Knife

Cutter sleeve

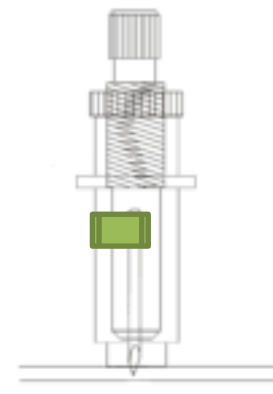
2.2 According to different cutting media, the length of the knife tip should be adjusted
at any time.



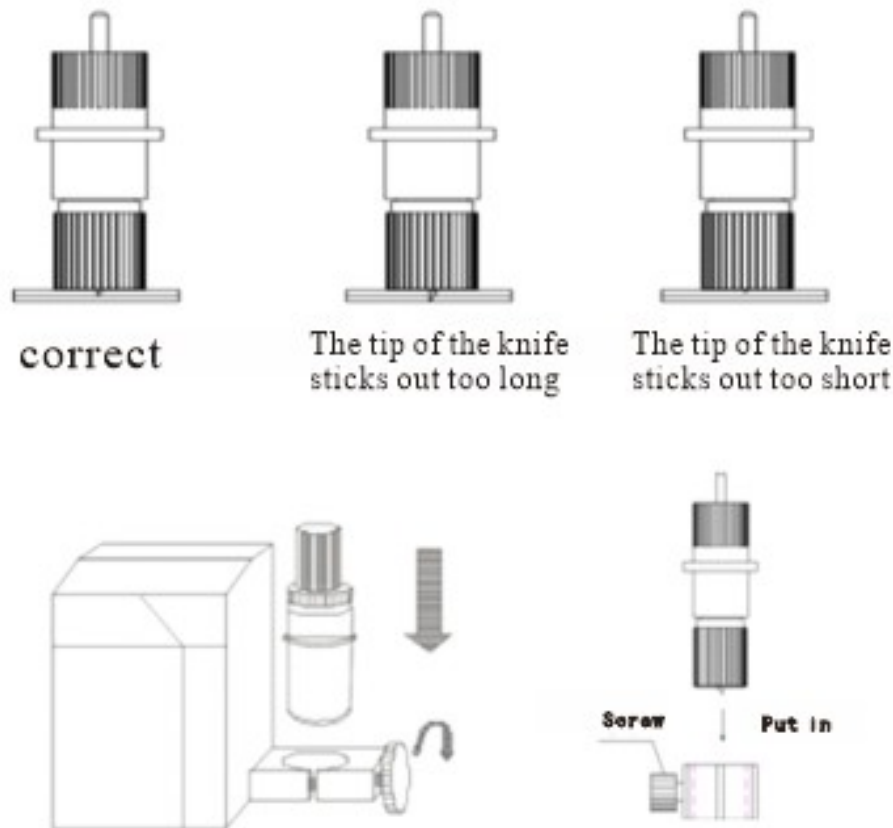
correct



The tip of the knife
sticks out too long



The tip of the knife
sticks out too short



2.3

- (1) Loosen the fixing screws on the tool holder.
- (2) Insert the tool with the blade into the tool holder.
- (3) After the tool reaches a certain position, tighten and fix the screws.

Section 3.: Test tool (adjusting tool pressure and tool)

Test button: 



CAUTION

Do not touch the tip of the knife with your fingers.

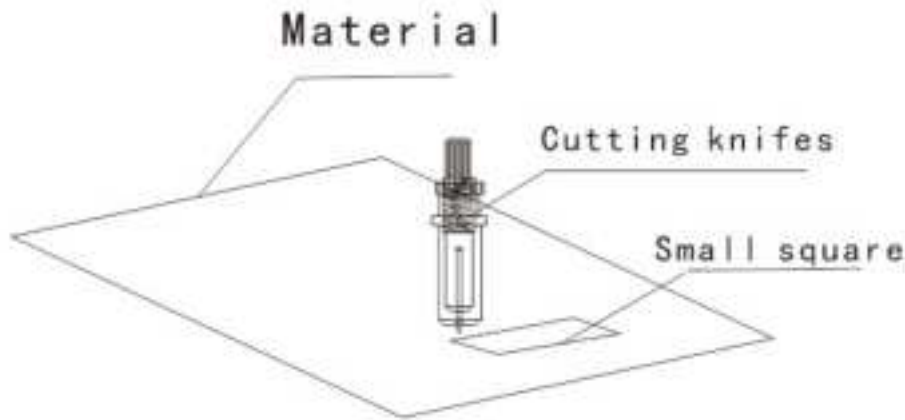
This can lead to broken fingers.

The quality of the cutter directly affects the accuracy of the cutting and the life of the machine, and can have a better working effect, please choose the regular cutter confirmed by the company, do not use the inferior cutter, otherwise it will lead to the damage of the cutter holder.





3.1 In manual mode, hold down “**Test**”, the machine automatically cuts a small rectangle.



3.2 Uncover this small rectangle, if it cannot be removed, it indicates that it has not been cut through, because the protruding part of the tip is too short or the knife pressure is too small. If the backing paper is cut through, it means that the protruding part of the knife tip is too long or the knife pressure is too large. According to the situation of the test tool, adjust the length of the tool head and the size of the knife pressure according to the installation tool, so as to cut through the surface material and the slight scratch on the bottom paper is the best.

Section 4 :Executing U disk files

Use the specified software output **xx.PLT** format file into the **U disk** (The U disk needs to be formatted in **FAT32** format) , insert the U disk into the machine, hold down  to interface.



Select the file you want to work on, the status display area becomes a dark file name, later hold down  start work.

Section 5: Automatic paper feed Settings



Figure II

Press "About this Machine" in the upper right corner of the main page to go to the interface

in Figure 2 , press  , Material bin Materials are automatically placed on the

device , press  , The paper roller will turn, (Note: This page is not commonly used only for test adjustment pressure test proportional test calibration).

Section6:Function introduction



Figure I

Figure II

Press the menu key  to the interface in Figure II, there are eight function setting keys.

6.1 Calibration



Figure I

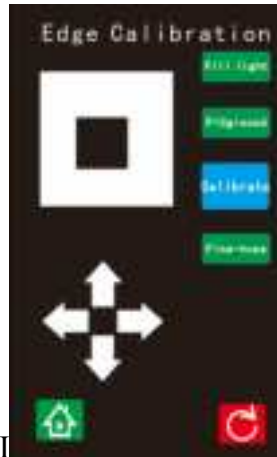


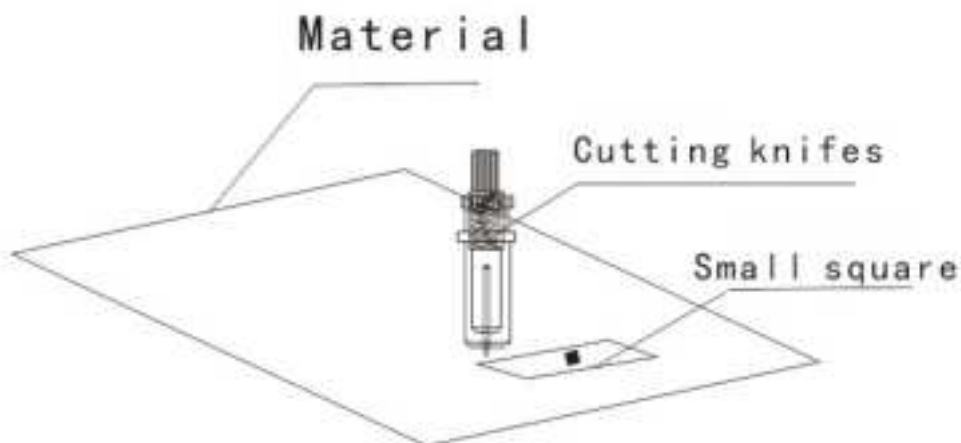
Figure II



Figure III

Figure I Press the paper feed key, the material enters the machine, and then install the cutter seat.

Move the arrow key to move the cutter seat directly above the material.



Cut 2 Cut the rectangle, black the middle rectangle, tear off the outer frame, and calibrate the camera according to "Calibrate" in Figure II.

When finished, cut a center line, as shown in Figure III, to complete the calibration.

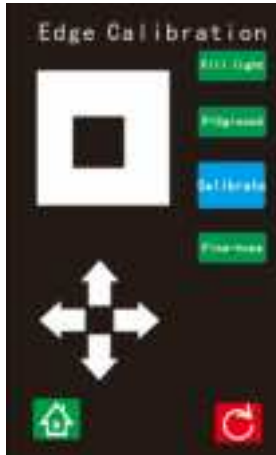


6.1.1

Correctly use the white material to enter the machine platform, move the camera position to the white area and click.

6.2 Fine adjustment

If the cut is offset, the function key enters



“fine adjustment” in “calibration”; As shown at left, hold down



save the adjusted parameters.

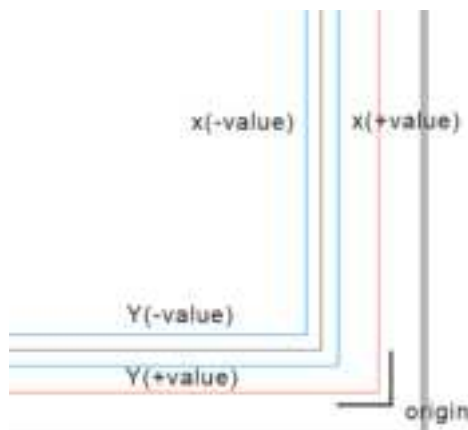


Figure I



Figure II

In Figure I, the black line is the correct position and the blue line is the offset position. The distance between the black line and the blue line is measured, is the value you want to set,

If we actually shift to the right we need to subtract landscape the corresponding value;

If you actually shift it to the left you need to add landscape the corresponding value;

If you actually shift it up you need to add portrait the corresponding value;

If we actually offset it down we need to subtract portrait the

corresponding value.

Section7:Scale X, Y-axis scale Settings (The general factory ratio is set without modification, if there is an error in the proportion of the machine used);



First click the feed button Material enters the machine platform

Press the menu key  to ;



Enter "gear ratio"

Click to enter



Figure I below



Figure I



Figure II

Click "Cut" Enter the cut 200*200mm box and measure the actual value. For example, the

transverse actual value is 199.8mm, The actual longitudinal measurement value is 200.3mm, which should be set according to the actual situation.



later press , save the adjusted parameters.

Section 8. How to Connect Network Ports

Step 1: Connect the network cable to the machine as shown in Figure 1; Figure 2 shows how to connect the other end of the network cable to the router.



Figure 1



Figure 2

Step 2: Click the function key and "Network Port" to enter the interface in Figure 4 below. Click "Obtain IP Address" to display OK, and the corresponding new IP address appears, indicating that the connection is successful.



Figure 3



Figure 4

Step 3: Open the computer software output interface Computer port setting type select TCP/IP ; IP address Enter the IP number obtained in Figure 2. Set the port number to 8080 (Note: The network connected to the machine and the network used by the computer must be the same LAN, otherwise the transmission will not succeed)



Section 9.how to set up a USB cable to connect the machine to work

Connect the machine to the computer via USB cable; Open the software port Settings (Figure 1)



Figure 1

Common fault analysis

Q: Why was the scan not performed, or was the location wrong?

A: 1. The engraving machine camera does not scan on the mark point, and the offset needs

to be set in the calibration.

2. Put the blank paper into the machine, and move the camera to the blank space for background reset.

3. Recalibrate

Q: Why is it out of position?

A: 1. When printing, zoom in and out, check whether the size of the picture at the printing place is consistent with the size set by the computer software.

2. Calibrate "Fine-tune" to fine-tune the offset value.

Q: Why is the lower right accurate, and the rear and left zoomed in or out?

A: 1, first adjust the cutting fine-tuning to the lower right accurately, and then enter the gear ratio. Test ratio, enter the gear ratio test calibration.

Q: Why does the startup car stop working?

A: 1. Check whether the machine is powered on normally.

2. Check if the metal bar or other wire ends inside the machine are loose and fall off.

3. Replace the metal cable.

Q: Why doesn't the image mark appear on the screen when scanning the mark for the camera?

A: 1. If the connection line between the camera on the car and the small car plate is loose or damaged, replace it.

2. Check whether there are occlusions on the camera lens.

3. Replace the metal cable.

Q: Why do U disk files not perform cutting?

A: U disk file must specify the format of the software saving (for example: the U disk file saved by the built-in CDR/AI plug-in) .

Q: Why does the output not work after connecting the machine?

A: If the data line is connected to the engraving machine, it can be excluded according to the following methods:

- 1, Check whether the serial port and transmission rate are set correctly;
- 2, if it is a USB cable, please confirm whether the port is correct;

Q: Why is it that after engraving output, one side will be transparent and the other side will not be transparent?

- A: 1, the knife installation is too long, beyond the thickness of the material;
- 2, the pressure is too small, the normal pressure is more than 200;
 - 3, engraving machine pad blade wear, need to be replaced;

Q: Will small characters below 1CM be deformed?

A: To carve small characters, you need to set sharp corner compensation in the software.

For example, in the Wentai engraving software:

1. Click "Engraving Output" to pop up the engraving output screen;
 - 2, click "Settings", the engraving machine Settings screen appears;
 3. Click "Compensation Settings" to pop up the dialog box;
 - 4, select "sharp Angle compensation",
- adjust the required value size to achieve the ideal effect.

The compensation value is between 0.1 and 0.7, and the general set value is 0.25. In addition, the engraving speed of the cutting machine should be set below 100.

Q: Why is there an extra stroke after the inscription?

- A: 1, first check whether the cutter head is not flexible;
- 2, if some words are not normal, please replace the engraving software;
 3. Check whether there is any problem with the document.
 - 4, exclude whether the machine is connected with ground.

Q: Why does the engraving output "crash"?

A: 1, When the external 220V input voltage is too low (150V), the lettering machine will

restart and "crash" will appear.

2, the external 220V input voltage interference is too large, there will be a crash, check the surrounding 220V, the solution can use AC purification voltage regulator power supply.

Q: Why do machines sometimes feel numb to the touch?

A: It is caused by poor grounding of the power supply. Please make sure that the middle line of the power supply is grounded.

Q: Why will the sharp corners be picked up when cutting characters, not smooth?

A: 1, the knife tip extends the knife sleeve is too long, please adjust according to the regulations.

2, the knife wear, replace the knife can.

Q: Why do die cutting machines sometimes draw a line before they can be engraved and output?

A: Because the last engraving abnormal exit, in the engraving machine memory did not clear the knife instruction. The solution is turn off the power and turn it on again to re-print the output.

Q: Does the LCD display nothing or a small row of black blocks?

A: 1, If no display is displayed, the power supply may not work. Check whether the power supply works normally.

2, black block display please check the power supply voltage is normal? If the problem persists, please contact the maintenance station.

Q: Why does cutting sometimes not close?

A: The cutter is an eccentric cutter and has an eccentric value, so the cutter will not close. The solution is to set "closure compensation" in the software.

For example, in Wentai software:

1. Click "Engraving Output" to pop up the engraving output screen;
- 2, click "Settings", the engraving screen will pop up;
3. Click "Compensation Settings" to pop up the dialog box;
- 4, select "closed compensation", adjust the required value size, you can achieve the ideal effect, the general set value is 0.5.

Q: Why will there be stroke leakage phenomenon when engraving?

- A: 1, check the machine pressure value is appropriate;
2. Reinstall the operating software;
 3. Check whether the tool head is flexible;
 - 4, if the problem still exists, please contact the maintenance center.

Q: Why do I cut a deep cut and a shallow cut?

A: Because the cutting machine uses advanced soft PVC material as the pad blade, in order to protect the carving knife. However, if the use time is too long, the pad will produce a scratch, so that the pad knife is uneven, and there will be a deep and shallow phenomenon when the word is cut. At this time, replace the knife bar. In the case of not serious, the knife can be adjusted according to section 3.2.2, and the knife pressure can be increased (about 200-300), which can temporarily solve the problem.

Q: Engraving output, engraving machine does not move what to do?

- A: 1, check whether the cutting machine and the computer online is correct; The cutting machine uses the COM1 or COM2 serial port of the computer to communicate, check whether the communication port set in the computer is consistent with the communication port connected to the hardware.
- 2, check whether the die cutting machine is online.
 - 3, check whether the computer software encryption card is installed, if not, please turn off the power and reinstall.
 - 4, check the software set cutting machine driver.

Q: What should I do if I can't remove the Post-IT note after cutting the characters?

A: 1, Test knife should be carried out before output and the pressure should be adjusted to the appropriate size.

2, check whether the carving knife is used for too long, whether the tip of the knife is broken, the scratch of the new knife is very thin, and the scratch of the old knife is thicker and obvious. Try it with a new carving knife.

Q: How to maintain the die cutting machine?

A: The cutting machine all use Japanese advanced oil-bearing, long-term operation without refueling. After finishing the work every day, clean the dust with a soft brush. Glue left on the frame can be cleaned with alcohol. Long-term operation in a dusty environment, more than 2 years of use should ask maintenance personnel to remove the dust in the machine, such as the engraving accuracy is reduced, but also to maintain the moving parts (fastening and replacing worn parts).

Q: Why do die-cutting machines sometimes get out of control?

A: It may be that during transportation or use, the signal feeder is in poor contact, turn on the machine and plug all the lines. However, if it cannot be solved, please contact your local agent or customer repair center.

Q: Why does the film cutting machine stop?

A: This is due to long-term vibration or long-term use, temperature effect, so that the servo drive board potential drift, frequent downtime phenomenon, please contact the local agent or customer maintenance.